

Date: Thursday, 9/14/2006 1:08:24 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 28598  
 Estimate Number : 10364  
 P.O. Number : N/A Part Number : D3046041  
 This Issue : 9/14/2006 S.O. No. : N/A Drawing Number : D3046 REV. A *UNDER REVIEW*  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : 28435 Material : N/A  
 Due Date : 9/25/2006 Qty: 6 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 06.09.14  
 Comment : Est: A 01.08.20 New issue SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

LUG BRACKET

Qty Part Number Description Batch  
 1 D3046-1 Lug Bracket

*B 28599 ④ x1*  
*328440 ①*  
*B 27196 ①*

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

LUG BRACKET

Pick:

Qty Part Number Description Batch  
 1 D3046-3 ( Bell P/N: 206-052-106-1) Lug Bracket N/A

Return Authorization #

Bell original batch#

*RTN SIS (28499)*  
*P2930-1/18388/P4047/P2935/02930/P2935*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

*FF 06-09-26*

*SA 06:09:26 6*

4.0 MS20426AD57 Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

Qty Part Number Description Batch  
 10 MS20426AD5-7 Rivet

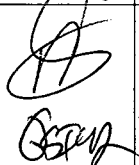
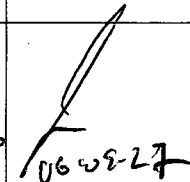

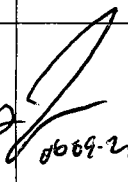
*M 7681*

*SB 06/09/27 6*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/28  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/26	3	1 part was scrap countersink to deep		Scrap + replace	SB 06/09/26	 06-09-27	 06-09-26	 06-09-26

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28598

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3046

SP 06/09/27 (6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-27 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Q-m 06-09-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06-09-28 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: N/A

Q

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06-09-28

Job Completion



u 06-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

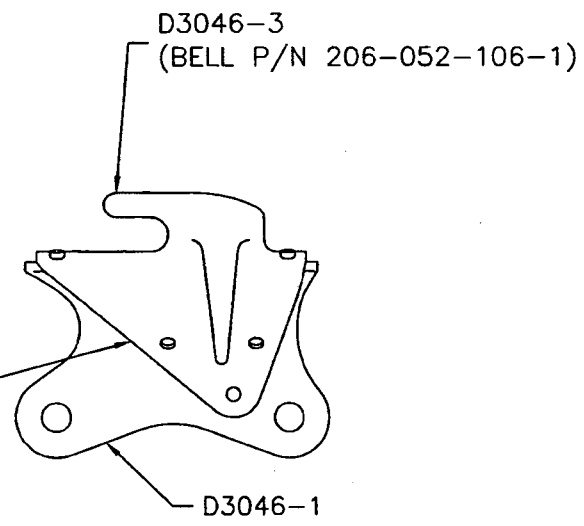
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



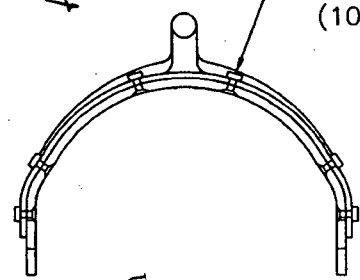
DESIGN		DRAWN BY		DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 2	
CHECKED	APPROVED	DRAWING NO.		SCALE	
01.08.23	01.08.23	D3046		1:2	
DATE	TITLE	LUG BRACKET		NEW ISSUE	
A	01.08.23	01.08.23		NEW ISSUE	



TRANSFER DRILL  $\phi 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\phi 0.286 \times 100'$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)

CENTER D3046-3  
ON D3046-1

D3046-041 LUG BRACKET ASSEMBLY



UNDER REVIEW  
DESIGNING TO WRITER  
DESIGN

RELEASED  
01.08.23

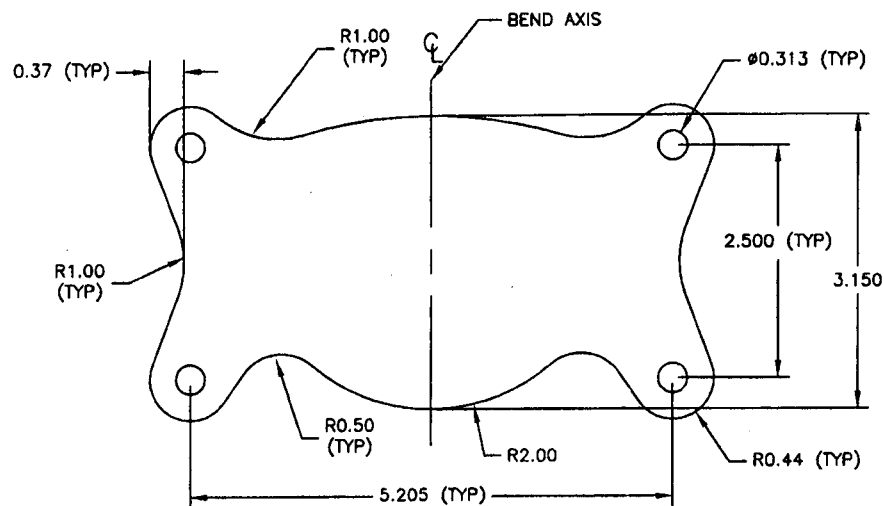
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO ADVISEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28598

NOTES:

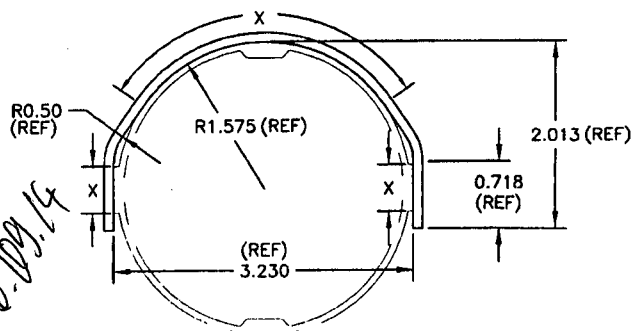
- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (C)



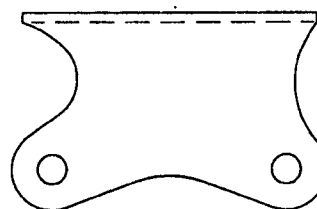
D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



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NO. 28598

RELEASED  
01.08.27

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